

Date: Friday, 01/02/2008 9:28:53 AM  
 User: Linda Lacelle

## Process Sheet

|                       |   |          |                  |                  |                   |     |      |
|-----------------------|---|----------|------------------|------------------|-------------------|-----|------|
| Customer              | : CU-DAR001 Dart Helicopters Services             |          |                  | Drawing Name     | : AFT BASE        |     |      |
| Job Number            | : 37139   |          |                  | Part Number      | : D365111         |     |      |
| Estimate Number       | : 13036   |          |                  | Drawing Number   | : D3651 REV.B U/R |     |      |
| P.O. Number           | :   |          |                  | Project Number   | : N/A             |     |      |
| This Issue            | : 01/02/2008                                      | S.O. No. | :                | Drawing Revision | : B U/R           |     |      |
| Prsht Rev.            | : NC  |          |                  | Material         | :                 |     |      |
| First Issue           | : / /   | Type     | : SMALL /MED FAB | Due Date         | : 08/02/2008      |     |      |
| Previous Run          | : 35848   |          |                  | Qty:             | 2                 | Um: | Each |
| Written By            | :   |          |                  |                  |                   |     |      |
| Checked & Approved By | :   |          |                  |                  |                   |     |      |
| Comment               | : Est Rev:A New Issue 07-09-27 DD verified by: EC |          |                  |                  |                   |     |      |
|                       | Est Rev:B ECN 1113P 08-01-22 DD                   |          |                  |                  |                   |     |      |

## Additional Product

Job Number:



| Seq. #:  | Machine Or Operation: | Description :                             |
|--|-----------------------|---|
| 1.0  | G89                   | coated cloth                              |
|  |                       |   |
| Comment: Qty.: 0.7203 sf(s)/Unit Total : 1.4406 sf(s)<br>G-89 coated cloth<br>Batch: 105928 LB 8-2-1   |                       |   |
| 2.0  | WATER JET             | FLOW WATER JET                            |
|  |                       |   |
| Comment: FLOW WATER JET<br>1-Cut as per Dwg D3651  |                       |   |
| Dwg Rev: B LB 8-2-1<br>Prog Rev: B   |                       |   |
| 2-Deburr if necessary  |                       |   |
| 3.0  | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE    |
|  |                       |   |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE<br>LB 8-2-1  |                       |   |
| 4.0  | QC8                   | SECOND CHECK<br>ENGINEERING APPROVAL 0204 |
|  |                       |   |
| Comment: SECOND CHECK  |                       |   |
| 5.0  | PACKAGING 1           | PACKAGING RESOURCE #1                     |
|  |                       |   |
| Comment: PACKAGING RESOURCE #1<br>Identify and stock<br>Location: PPO 38103 - 8/3/18 (2) B 0803.13 (2) |                       |   |

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 37139

Part Number: D365111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08.03.18  
CH

Comment: FINAL INSPECTION/W/O RELEASE

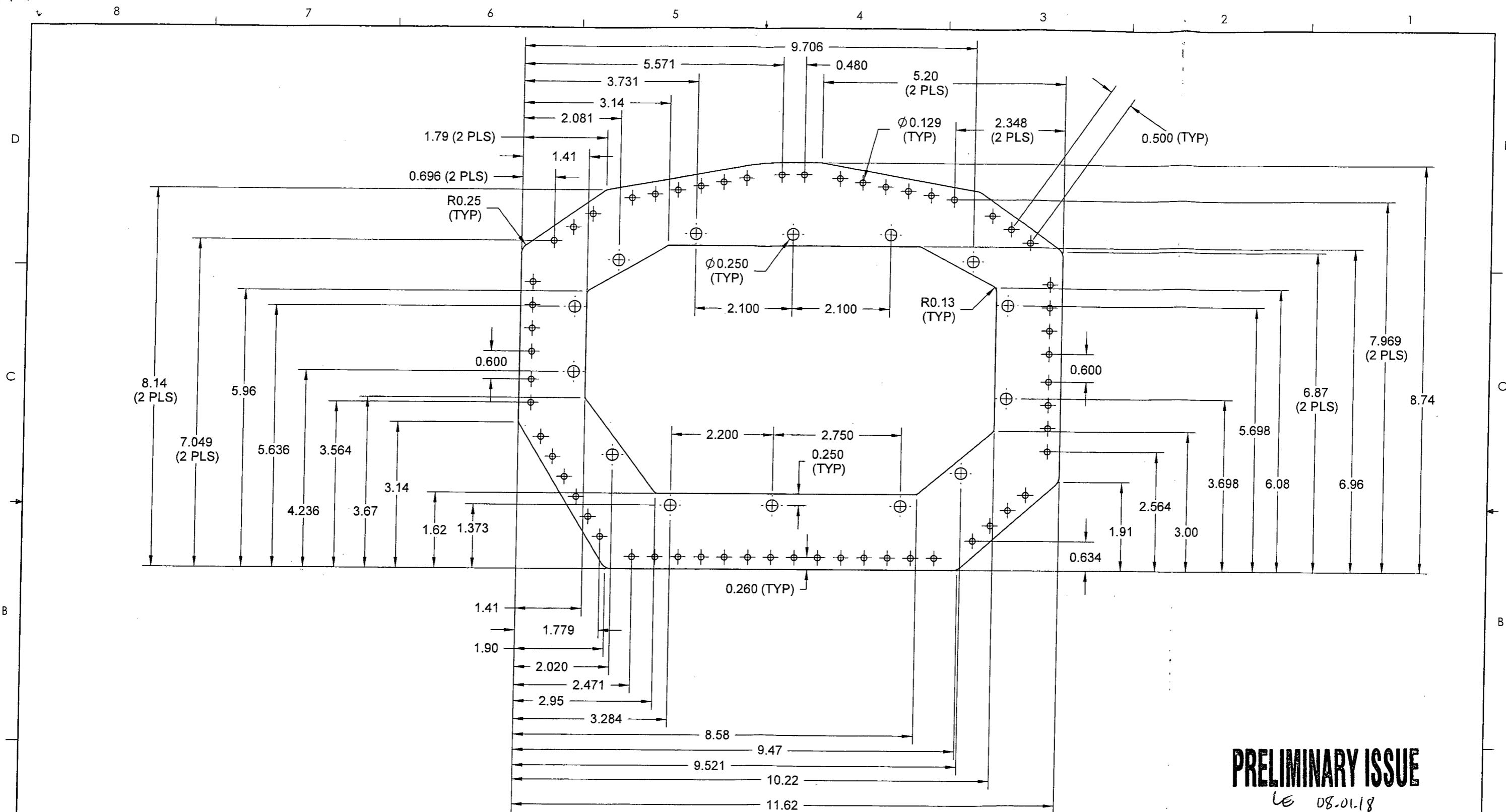
Job Completion



U 88.03.14

POSITIVE RECALL

EFFECTIVE 08.02.01 AUTH         
RELEASED AB DATE 08.03.18



NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.2 lb

D3651-11 GASKET 

|              |   |   |
|--------------|---|---|
| DESIGN DRAWN | RF  | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED      | RF  |   |
| MFG. APPR.   |  | DRAWING NO.<br>D3651                              |
| APPROVED     |  | REV. B<br>SHEET 8 OF 9                            |
| DE APPR.     |  | TITLE<br>AFT BASE ASSEMBLY                        |
| DATE         | 08.01.07  | SCALE<br>1:2                                      |

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DART AEROSPACE LTD

Work Order: 37139

Description: AFT BASE GASKET

Part Number: D3651-11

Inspection Dwg: D3651-11 Rev: B

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

 First Article  Prototype

| Drawing Dimension | Tolerance   | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-------------|------------------|--------|--------|----------------------|----------|
| Ø .139            | +.004 -.001 | .139             | X      |        |                      |          |
| Ø .250            | +.005 -.001 | .250             | X      |        |                      |          |
| 8.74              | +/-.030     | 8.74             | X      |        |                      |          |
| 11.62             | +/-.030     | 11.62            | X      |        |                      |          |
| 1.62              | +/-.030     | 1.62             | X      |        |                      |          |
| 1.41              | +/-.030     | 1.41             | X      |        |                      |          |
| .500              | +/-.010     | .500             | X      |        |                      |          |
| .600              | +/-.010     | .600             | X      |        |                      |          |
| .634              | +/-.010     | .634             | X      |        |                      |          |
| 2.564             | +/-.010     | 2.564            | X      |        |                      |          |
| 2.081             | +/-.010     | 2.081            | X      |        |                      |          |
| 3.731             | +/-.010     | 3.731            | X      |        |                      |          |
| 2.100             | +/-.010     | 2.100            | X      |        |                      |          |
| 9.706             | +/-.010     | 9.706            | X      |        |                      |          |
| 7.969             | +/-.010     | 7.969            | X      |        |                      |          |
| 6.96              | +/-.030     | 6.96             | X      |        |                      |          |
| 5.698             | +/-.010     | 5.698            | X      |        |                      |          |
| 3.698             | +/-.010     | 3.698            | X      |        |                      |          |
| 2.564             | +/-.010     | 2.564            | X      |        |                      |          |
| 2.020             | +/-.010     | 2.020            | X      |        |                      |          |
| 3.284             | +/-.010     | 3.284            | X      |        |                      |          |
| 2.200             | +/-.010     | 2.200            | X      |        |                      |          |
| 2.750             | +/-.010     | 2.750            | X      |        |                      |          |

Measured by: KB  
Date: 8-2-04

Audited by: C  
Date: 06/02/04

Prototype Approval: K  
Date: 08.02.04

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |



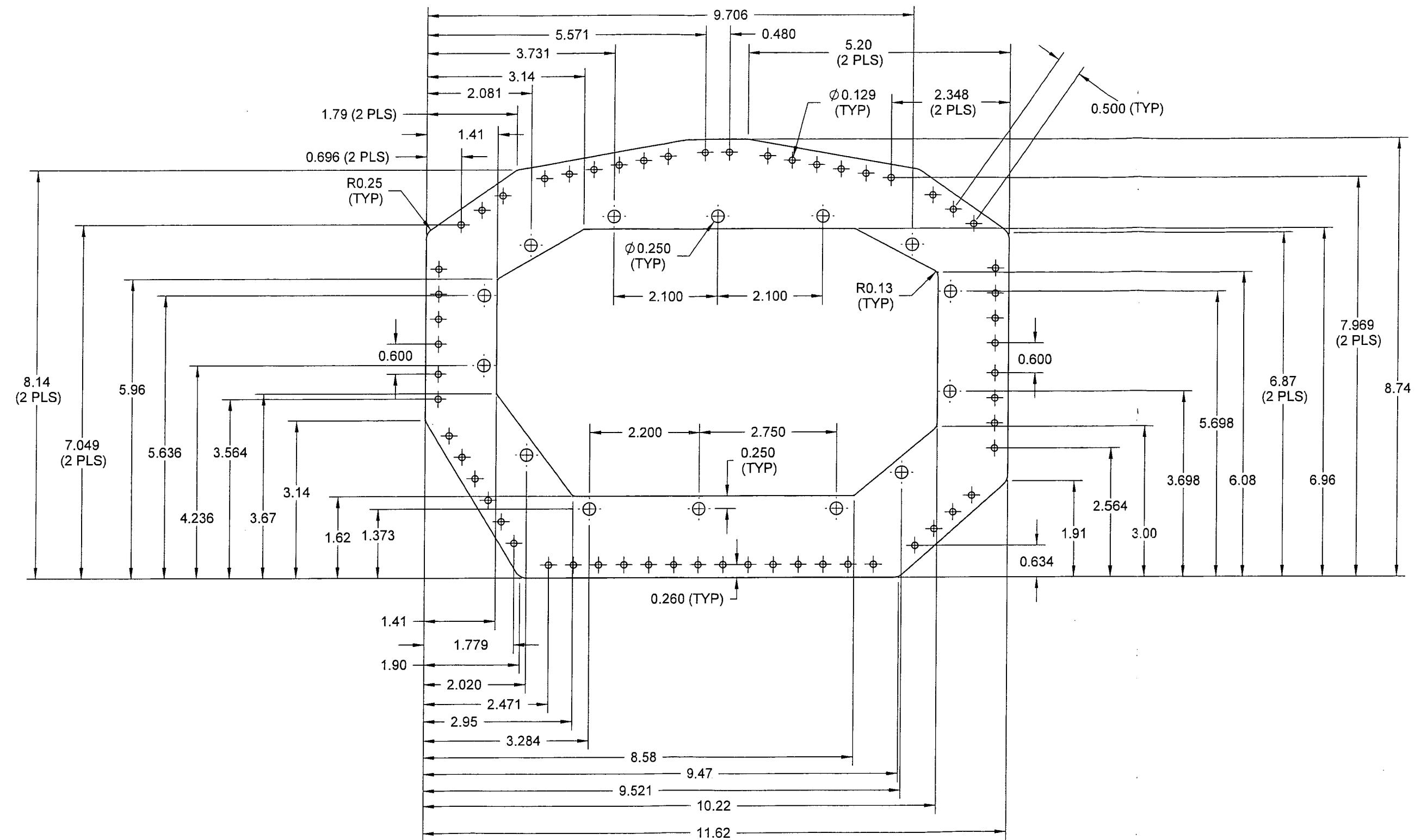
|                                 |              |             |
|---------------------------------|--------------|-------------|
| DART AEROSPACE LTD              | Work Order:  | 37139       |
| Description: AFT BASE GASKET    | Part Number: | D3651-11    |
| Inspection Dwg: D3651-11 Rev: B |              | Page 1 of 1 |

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

|                        |                       |                               |
|------------------------|-----------------------|-------------------------------|
| Measured by: <u>BB</u> | Audited by: <u>J</u>  | Prototype Approval: <u>UE</u> |
| Date: <u>8-2-14</u>    | Date: <u>08/02/14</u> | Date: <u>08-03-13</u>         |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |



## NOTES

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**D3651-11 GASKET**

|            |           |  |              |
|------------|-----------|--|--------------|
| DESIGN     | RF        | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | RF        | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | <i>LE</i> | DRAWING NO.  | REV. B       |
| MFG. APPR. | <i>AN</i> | D3651  | SHEET 8 OF 9 |
| APPROVED   | <i>TW</i> | TITLE  | SCALE        |
| DE APPR.   | <i>LE</i> | AFT BASE ASSEMBLY  | 1:2          |
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